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D3914-041
Job Sheet 166662



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/13/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/30/17	0.00	0.00	Start up container	
100	Large Fab	1 pcs	10/30/17	0.00	6.67	Large Fab 1	17-11-06
110	QC	1 pcs	10/30/17	0.00	0.00	QC9	17-11-06
120	QC	1 pcs	10/30/17	0.00	0.00	QC5	17-11-06
130	Powdercoat	1 pcs	10/30/17	0.00	0.40	Powdercoat4	17-11-06
135	QC	1 pcs	10/30/17	0.00	0.00	QC3	17-11-06
140	HandFinish	1 pcs	10/31/17	0.00	0.80	HandFinish3	17-11-06
150	QC	1 pcs	10/31/17	0.00	0.00	QC3	17-11-06
160	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging3	17-11-06
170	QC21-SA	1 Ea	10/31/17	0.00	0.00	QC21	NOV 14 2017

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M 136370 START: 3:30 OVT: 3:00 FINISH: 4:00

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581	2	28	0	0
	D3914-1165914	2	4	0	0
	D3914-7	2	2	0	0
	D4016-3160518	3	22	0	0
	D4018-5	9	18	0	0
	D4020-55001023	1	1	0	0
	D4021-3	1	8	0	0
	D4035-043	2	2	0	0
140-HandFinish	D2728-3	1	0	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐	
 S007275 Long Basket Lid Assembly (350)		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com			
PART NO: D3914-041 Revision: Operation: Start up Operation Quantity: 1 Change No:		Mfg Date: 11/07/17 Job No: 166662			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Centre not concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					